

Date: Wednesday, 28/01/2009 5:02:34 PM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: "T" HANDLE ASSEMBLY	
Job Number	: 45347A		Part Number	: D2282041	
Estimate Number	: 11179		Drawing Number	: D2282 REV E	
P.O. Number	:		Project Number	: N/A	
This Issue	: 28/01/2009 S.O. No. :		Drawing Revision	: E	
Prsht Rev.	: NC		Material	:	
First Issue	: / /		Due Date	: 28/02/2009	
Previous Run	: 44403A		Qty:	100	
Written By	:		Um:	Each	
Checked & Approved By	: <u>JVD 09.01.29</u>			98x	
Comment	: Est Rev:A			Removed from 9 Digit	
	05-12-02 JLM				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D22823	Tube	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 100.0000 Each(s)	
		Pick:	
	Qty Part Number	Description Batch	
	1 D2282-3	Handle tube <u>B441443 = 22x</u> 7 8 98x	
		<u>B44384 = 60x</u>	
		<u>B44428 = 18x</u>	
		SP. 09. 03. 25	
2.0	D22825	Tube	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 100.0000 Each(s)	
		Pick:	
	Qty Part Number	Description Batch	
	1 D2282-5	Handle tube <u>B44338 = 8x</u> 5 90x	
		<u>B44320 = 30x</u>	
		SP 09.03.25	
3.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1	

Comment: LARGE FABRICATION RESOURCE 1

1-Weld as per D2282-041 'T' Handle Assembly
 Grind chamfers and ensure full penetration as per dwg D2282
 *****brush weld right after welding, to take color off *****

A/R ER316L SS Filling Rod H10615
 Dwg Rev: E

SP 09.04.06

W/O:		WORK ORDER CHANGES				
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 28/01/2009 5:02:35 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: "T" HANDLE ASSEMBLY

Job Number: 45347A

Part Number: D2282041

Job Number:



Seq. #: Machine Or Operation:

Description :

4.0 QC9 ,



VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

QC 09.04.07

5.0 SMALL FAB 1



SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Tumble

BB 94-22

6.0 QC5



INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 09/04/22

7.0 PACKAGING 1



PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *B-A*

SB 09/04/22 99

8.0 QC21



FINAL INSPECTION/W/O RELEASE



09/04/23

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



09.04.23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

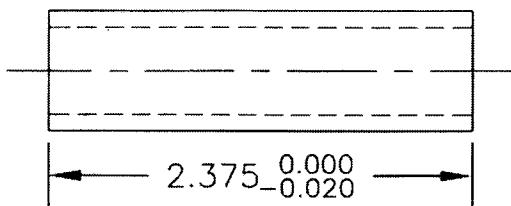
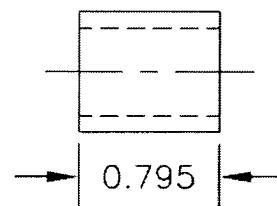
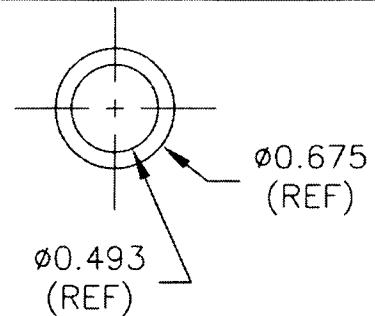
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

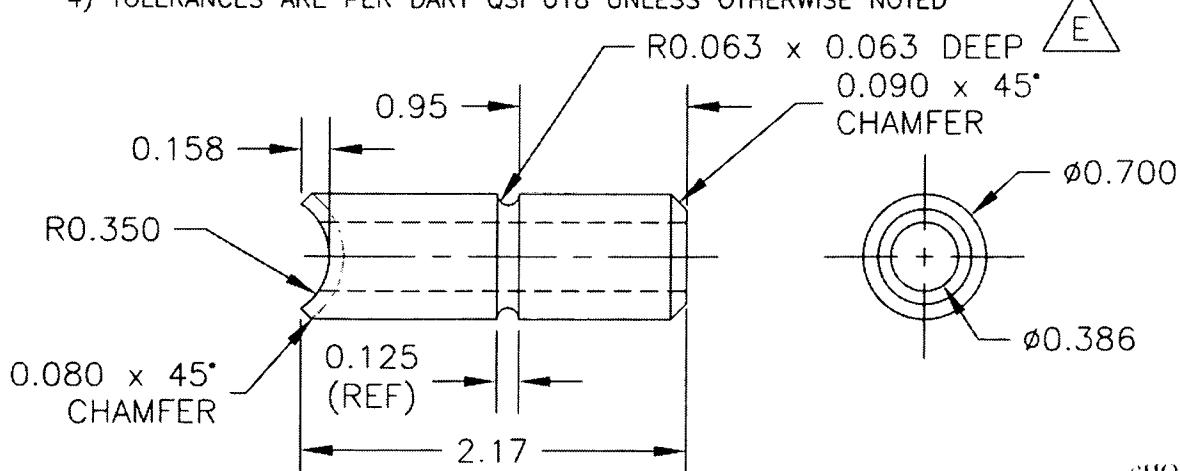
DESIGN BW	DRAWN BY <i>EW</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>IP</i>	APPROVED <i>AP</i>	DRAWING NO. D2282	REV. E SHEET 1 OF 2
DATE 05.06.07		TITLE HANDLE TUBES	SCALE 1:1

RELEASED
05/07/11

**D2282-3****D2282-7**

D2282-3/7 TUBE:

- 1) MATERIAL: T304/T316 3/8 SCHEDULE 40 (REF. DART SPEC. M304TR0.675W.091)
- 2) BREAK ALL UMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

**D2282-5****D2282-5 STEM:**

- 1) MATERIAL: AISI 304 STAINLESS STEEL (REF. DART SPEC. M304R0.750)
- 2) BREAK ALL UMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY

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PRINTING

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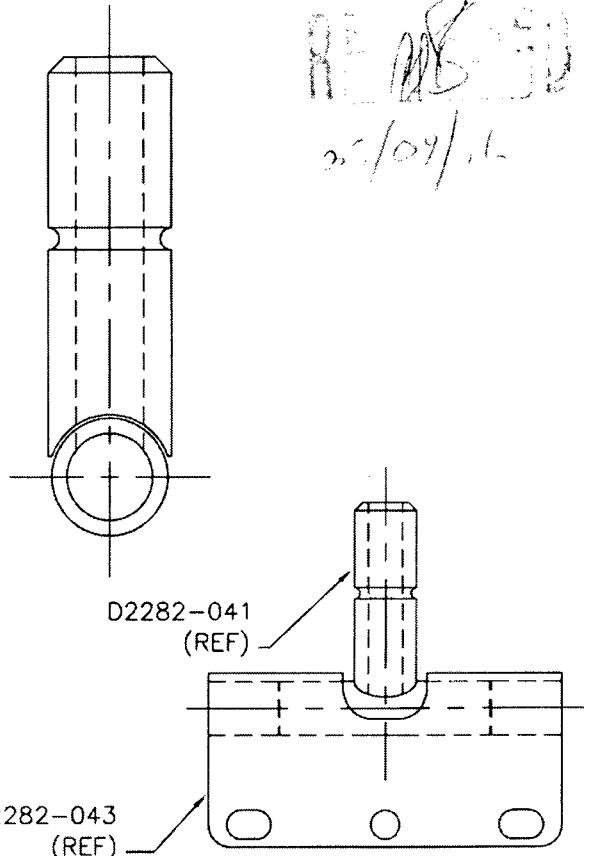
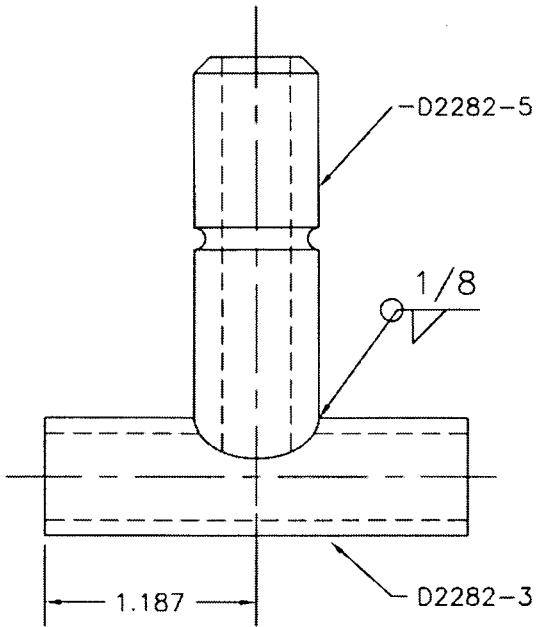
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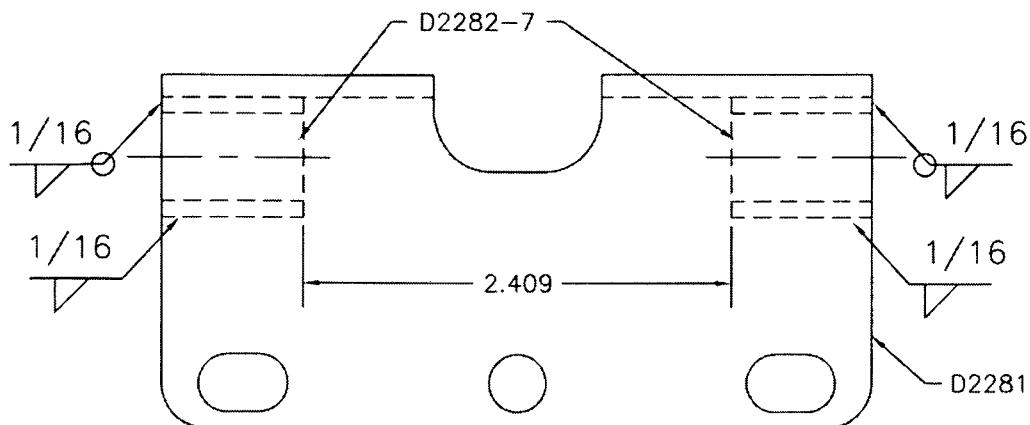
NO. 15367A

DART

DESIGN BW	DRAWN BY <i>FT</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>IP</i>	APPROVED <i>W</i>	DRAWING NO. D2282	REV. E SHEET 2 OF 2
DATE 05.06.07		TITLE HANDLE TUBES	SCALE 1:1



D2282-041 'T' ASSEMBLY
WELD ASSEMBLY PER DART QSI 004



D2282-043 SADDLE ASSEMBLY
WELD ASSEMBLY PER DART QSI 004

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ENGINEERING
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WITHOUT NOTICE
WORK ORDER
NO. *WS347A*